DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-024743
Date Inspected: 12-Jun-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	N/A		**CWI Present:**	☑ Yes	☐ No
Inspected CWI report:	☐ Yes	☐ No ☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No ☑ N/A
Electrode to specification:	☐ Yes	☐ No ☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No ☑ N/A
Qualified Welders:	☐ Yes	☐ No ☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No ☑ N/A
Approved Drawings:	☑ Yes	☐ No ☐ N/A	**Approved WPS:**	☐ Yes	☐ No ☑ N/A
			Delayed / Cancelled:	☐ Yes	☑ No ☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Blast shop #4, Segments 13AW, 13BW and 13CW

Caltrans and ABF have agreed to conduct visual and magnetic particle inspections of segment 13AW welds as part of a special reinspection program reference NWIT# 9480.

This QA Inspector observed ABF performing MT inspections of weld OBW13-001 from plate KP3015A to the center of segment 13AW (DP3121A/DP3035A) and temporary alignment plate removal areas adjacent to OBW13-001 near plate LD3034A and LD3035A. See drawings SEG3013B and SEG3014H for additional information. ABF identified MT linear indications in temporary alignment plate weld removal areas adjacent to weld OBW13-001 at Y=400mm on 13BW side of the weld and Y=790mm and Y=2560mm on the 13AW side of the weld as measured toward the center of the segment. ABF also performed MT inspections of the hold back welds on segment 13AW between plates KP3015A and deck plate SA7501A on the cross beam side, hold back weld between LD3034A and deck plate DP3122A and segment 13BW between plates KP3017A and deck plate DP3138 and hold back weld between LD3035A and deck plate DP3135A. ABF marked linear indications on the counterweight side of the hold back welds on both LD3035A to SA7501A and LD3035A to DP3135A. This QA Inspector performed random magnetic particle inspections of these welds and no additional linear indications were

observed. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report and the photographs below.

This QA Inspector observed ABF performing MT inspections of welds: SEG3013C-137, 232, 233, 236, 237, 242, 243, 244, 245, 252, 253, 256, 257, 260 and 126. ABF marked welds SEG3013C-126, 134, 243 and 261 as needing to be ground or weld repaired. Weld SEG3013C-126 has weld repairs at the following locations Y=650mm, 1870mm, 2000mm, 3200mm and 3650mm (Y measurements starting at the bottom of the weld). This QA Inspector performed random magnetic particle inspection of the following welds: SEG3013C-230, 242, 244, 252, 253, 256, 257 and 260 and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report.

Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer